



NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED, USE ONE OF THE FOLLOWING: A) CIMCOOL 5 STAR 49 B) TRIM SOL
2. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. WALL THICKNESS NOT TO BE LESS THAN .100 AFTER MACHINING IF NEEDED.
5. DIMENSIONS IN [] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.
6. STRESS RELIEVE FOR DIMENSION STABILITY BEFORE MACHINING
7. WELD SHALL BE GAS TUNGSTEN ARC (GTAW) OR TUNGSTEN INERT GAS (TIG)

SYN	CHANGE DESCRIPTION	BY	CHKD	DATE
	REVISIONS			

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DECIMALS ANGLES				
A2417800				
THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY				
ADVANCED PHOTON SOURCE				
K4-31				
BM1 FOE COLLIMATOR				
RECTANGULAR CHAMBER				
SCALE 1:2				
SHEET 1 of 1				
DRAWING NUMBER C P4105090404-310101-00				